



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D2666-1
Job Sheet 205436



Part No: D2666-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/20

Job Tracking No:

Due Date: 1/27/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	1/27/20		0.00	3.66	HAAS - 1		SBL 20/01/23
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	1/27/20		0.00	4.49	Conventional Mill - 1 - B4B		SBL 20/01/24
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	1/27/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S249928



Part: D2666-1

Job No: 205436

Serial No/Batch: S249928

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/23/20

						QC 2 - 57	SBL 2010/1/24
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 8 - 12	
						QC 8 - 14	SBL 2010/1/24
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	1/27/20	0.00	0.21		Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	SBL 2010-01-27
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	

				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)- B4B 11235590.	4 pcs	1/27/20	0.00 0.18	Powdercoat - 1 - B4B	
START: 8:25 A.T. 320P FINISH: 18:55				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	20-01-29.
160 QC 3	4 pcs	1/27/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	JAN 29 2020
170 Packaging 3-1 - Stock - B4B	4 pcs	1/27/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B St402	DAS 74 JAN 30 2020
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

DAS 34 9-89

DAS
82
9-89

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	1/27/20	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21
Part Op 100 - HAAS CNC Vertical Machine - Program batch number. Descriptions: 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	S247856	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-001	4	41	0	
Part Specifications					
Specifications could not be found.					

Plex 1/10/20 9:13 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 205436
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.122	.121	.121	
B	0.100	0.140		.129	.129	.129	.129	
C	2.470	2.510		2.495	2.495	2.495	2.495	
D	0.100	0.180		.136	.138	.140	.140	
E	0.210	0.230		.220	.220	.221	.220	
F	1.313	1.343		1.321	1.321	1.321	1.321	
G	0.240	0.260		.249	.249	.250	.249	
H	0.615	0.685		.660	.655	.655	.655	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.002	1.002	1.002	1.002	
K	0.235	0.240		.239	.239	.239	.239	
L	0.510	0.515		.511	.511	.511	.511	
M	0.100	0.120		.115	.115	.115	.115	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		.500	.499	.499	.500	
S	0.312	0.318		.312	.312	.312	.312	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		.316	.316	.316	.316	
W	0.540	0.560		.548	.548	.548	.548	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.258	.258	.258	.258	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject				accept	accept	accept	accept	accept

Measured by: SBL 57	Date: 20/01/24
Audited by: JMK 9-89	Date: 20/01/24
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	M

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					